

ELECTRODE MATERIAL FOR LITHIUM SECONDARY BATTERY,
ELECTRODE STRUCTURE COMPRISING THE ELECTRODE MATERIAL
AND SECONDARY BATTERY COMPRISING THE ELECTRODE
STRUCTURE

5

BACKGROUND OF THE INVENTION

Field of the Invention

The present invention relates to an electrode
material for a lithium secondary battery that
10 comprises a powder of particles comprising silicon as
a major component, an electrode structure comprising
the electrode material and a secondary battery
comprising the electrode structure.

Related Background Art

15 Recently, it has been said that because the
amount of CO₂ gas contained in the air is increasing,
global warming may be occurring due to the greenhouse
effect. Thermal power plants use fossil fuels to
convert a thermal energy into an electric energy,
20 however they exhaust a large amount of CO₂ gas,
thereby making it difficult to newly construct
thermal power plants. Accordingly, for effective use
of an electric power generated in thermal power
plants, the so-called load leveling approach has been
25 proposed wherein an electric power generated at night,
which is an excess power, may be stored in a
household secondary battery or the like, whereby the

stored electric power can be used during the daytime when electric power consumption increases.

In addition, the development of a high energy-density secondary battery has been demanded for electric vehicles that do not exhaust air pollutants such as CO_x , NO_x , and hydrocarbons. Further, the development of compact, lightweight, high performance secondary batteries is urgently demanded for applications in portable electrical equipment such as notebook personal computers, video cameras, digital cameras, mobile phones, PDAs (Personal Digital Assistant) or the like.

As such a lightweight, compact secondary battery, a rocking chair type battery referred to as "lithium ion battery" which, during a charging reaction, uses a lithium intercalation compound as a positive electrode substance for allowing lithium ions to be deintercalated from between layers thereof and uses a carbonaceous material represented by graphite as a negative electrode substance for allowing lithium ions to be intercalated between planar layers of a 6-membered network-structure formed of carbon atoms have been developed and partly put into practical use.

However, with this "lithium ion battery", because the negative electrode formed of a carbonaceous material can theoretically intercalate

only a maximum of $1/6$ of a lithium atom per one carbon atom, a high energy-density secondary battery comparable with a lithium primary battery when using metallic lithium as a negative electrode material has
5 not been realized.

If an amount of lithium more than the theoretical amount is tried to be intercalated in a negative electrode comprising carbon of a "lithium ion battery" during charging or charging is performed
10 under a high current density condition, there is a possibility that lithium metal may grow in a dendrite shape on the carbon negative electrode surface, resulting in an internal short-circuit between the negative and the positive electrodes due to repeated
15 charge/discharge cycles, so that any "lithium ion battery" which has a capacity more than the theoretical capacity of a graphite negative electrode has not provided a sufficient cycle life.

On the other hand, a high-capacity lithium
20 secondary battery that uses metal lithium for a negative electrode has been drawing attention but not put in practical use yet.

This is because the charge/discharge cycle life is very short. This short charge/discharge cycle
25 life is considered to be ascribed to the fact that metal lithium reacts with impurities such as water or organic solvents contained in the electrolyte to form

an insulating film or that the surface of a metallic lithium foil is not flat and has a portion at which an electric field is concentrated, whereby repeated charging/discharging causes lithium to grow in a
5 dendrite shape, resulting in an internal short-circuit between the negative and positive electrodes, thereby leading to the end of the battery life.

In order to suppress the progress of the reaction in which metal lithium reacts with water or
10 organic solvents contained in the electrolyte, which is a problem peculiar to the secondary battery using a metal lithium negative electrode, a method which uses a lithium alloy containing lithium, aluminum and the like as a negative electrode has been proposed.

15 However, this method is not currently in wide practical use because the lithium alloy is too hard to wind in a spiral form, and therefore a spiral-wound type cylindrical battery cannot be made, because the cycle life is not sufficiently long, and
20 because an energy density comparable to that of a battery using metal lithium for a negative electrode cannot sufficiently be obtained.

In order to resolve the above-mentioned problems, heretofor, U.S. Patent Nos. 6,051,340,
25 5,795,679, and 6,432,585, Japanese Patent Application Laid-Open Nos. 11-283627 and 2000-311681 and International Publication WO 00/17949 have proposed a

secondary battery that uses a negative electrode for a lithium secondary battery comprised of elemental tin or silicon.

U.S. Patent No. 6,051,340 has proposed a
5 lithium secondary battery that uses a negative electrode comprising an electrode layer formed of a metal that is alloyable with lithium such as silicon or tin and a metal that is not alloyable with lithium on a current collector of a metal material that is
10 not alloyable with lithium.

U.S. Patent No. 5,795,679 proposes a lithium secondary battery using a negative electrode formed of a powder of an alloy of an element such as nickel or copper with an element such as tin. U.S. Patent
15 No. 6,432,585 proposes a lithium secondary battery that uses a negative electrode with an electrode material layer containing 35% or more by weight of particles comprised of silicon or tin with a average particle diameter of 0.5 to 60 μm and having a void
20 ratio of 0.10 to 0.86 and a density of 1.00 to 6.56 g/cm^3 .

Japanese Patent Application Laid-Open No. 11-283627 proposes a lithium secondary battery that uses a negative electrode comprising silicon or tin having
25 an amorphous phase; Japanese Patent Application Laid-Open No. 2000-311681 proposes a lithium secondary battery that uses a negative electrode comprising

amorphous tin-transition metal alloy particles with a non-stoichiometric composition; and International Publication WO 00/17949 proposes a lithium secondary battery using a negative electrode comprising
5 amorphous silicon-transition metal alloy particles with a non-stoichiometric composition.

However, in the lithium secondary batteries according to the above-mentioned proposals, the efficiency of the electricity amount involved in
10 lithium release relative to the electricity amount involved in a first lithium insertion does not reach the same level of performance as a graphite negative electrode, so that further improvement in the efficiency have been expected. In addition, since
15 the resistances of the electrodes of the lithium secondary batteries of the above proposals are higher than that of a graphite electrode, lowering in resistance has been desired.

Japanese Patent Application Laid-Open No. 2000-
20 215887 proposes a high-capacity, high charging/discharging efficiency lithium secondary battery in which a carbon layer is formed on the surface of particles of a metal or semi-metal which is alloyable with lithium, in particular silicon
25 particles, through chemical vapor disposition using thermal decomposition of benzene or the like to improve electrical conductivity, thereby suppressing

volume expansion when alloying with lithium to prevent breakage of an electrode.

However, with this lithium secondary battery, while the theoretical charge capacity calculated for $\text{Li}_{4.4}\text{Si}$ as a silicon/lithium compound is 4200 mAh/g, an electrode performance allowing lithium insertion/release of an electricity amount exceeding 1000 mAh/g has not been attained, so that development of a high-capacity, long life negative electrode has been desired.

SUMMARY OF THE INVENTION

The present invention has been accomplished in view of the aforementioned problems, and it is an object of the present invention to provide an electrode material for a lithium secondary battery in which capacity drop due to repeated charging/discharging is small, and charge/discharge cycle life is improved, an electrode structure comprising the electrode material, and a secondary battery comprising the electrode structure.

A first aspect of the present invention is an electrode material for a lithium secondary battery comprising alloy particles comprising silicon as a major component and having an average particle diameter of 0.02 μm to 5 μm , wherein the size of a crystallite of the alloy is not less than 2 nm but no

more than 500 nm and an intermetallic compound containing at least tin is dispersed in a silicon phase (First Invention).

A second aspect of the present invention is an
5 electrode material for a lithium secondary battery comprising alloy particles comprising silicon as a major component and having an average particle diameter of 0.02 μm to 5 μm , wherein the size of a
10 crystallite of the alloy is not less than 2 nm but no more than 500 nm and an at least one intermetallic compound containing at least one element selected from the group consisting of aluminum, zinc, indium, antimony, bismuth and lead is dispersed in a silicon phase.

15

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic sectional view of a particle of an electrode material constituting the electrode material structure according to the present
20 invention;

FIGS. 2A and 2B are conceptual views schematically illustrating sections of an electrode structure comprising the negative electrode material of the lithium secondary battery according to an
25 embodiment of the present invention;

FIG. 3 is a conceptual view schematically illustrating a section of a secondary battery

(lithium secondary battery) of an embodiment of the present invention;

FIG. 4 is a cross-sectional view of a single layer, flat type (coin type) battery;

5 FIG. 5 is a cross-sectional view of a spiral-wound type cylindrical battery;

FIG. 6 is a scanning electron microscope photograph of the electrode material prepared in Example 1 of the present invention;

10 FIG. 7 is a view illustrating an X-ray diffraction profile of the electrode material prepared in Example 1 of the present invention;

FIG. 8 is a view illustrating a selected-area electron diffraction image of the electrode material
15 prepared in Example 1 of the present invention;

FIG. 9 is a transmission electron microscope photograph of the electrode material prepared in Example 1 of the present invention;

FIG. 10 is a transmission electron microscope
20 photograph of the electrode material prepared in Reference Example 1;

FIG. 11 is views illustrating the results of elemental mapping by means of the energy dispersive X-ray spectroscopy (EDXS) analysis of the electrode
25 material prepared in Example 1 of the present invention;

FIG. 12 is views illustrating the results of

elemental mapping by means of EDXS analysis of the electrode material prepared in Reference Example 1; and

FIG. 13 is a graphical representation showing the results of release/insertion cycle tests of the electrodes prepared in Examples 1 to 4 of the present invention and Reference Examples 1 to 4.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

Hereinafter, embodiments of the present invention will be explained with reference to the drawings.

The present inventors have previously found that by adding tin or copper to silicon and using a fine powder wherein the average particle diameter of alloy particles comprising 50% or more by weight of silicon element is not less than 0.1 μm but no more than 2.5 μm , a high-capacity lithium secondary battery can be manufactured.

The present inventors have newly found that with an electrode material in which an intermetallic compound comprising tin or at least one intermetallic compound comprising at least one element selected from the group consisting of aluminum, zinc, indium, antimony, bismuth and lead is dispersed in a silicon phase having a crystallite size of not less than 2 nm and not more than 500 nm, the capacity drop due to

repeated charging/discharging can further be reduced and the charge/discharge cycle life can be improved, to accomplish the present invention.

FIG. 1 is a schematic sectional view of a
5 particle of an electrode material that constitutes an electrode structure according to the present invention, in which reference numeral 103 denotes a particle of the electrode material (active material) comprising silicon as a major component according to
10 the present invention. The average particle diameter of this electrode material particle 103 is 0.02 μm to 5 μm . Further, this electrode material particle 103 is comprised of a silicon phase 106 and an
intermetallic compound 107 which contains tin or an
15 element selected from the group consisting of aluminum, zinc, indium, antimony, bismuth and lead.

That is, the electrode material 103 of the present invention is characterized in that an intermetallic compound 107 comprising tin or an
20 intermetallic compound 107 comprising an element selected from the group consisting of aluminum, zinc, indium, antimony, bismuth and lead is dispersed in a silicon phase having a crystallite size of 2 nm or more and 500 nm or less. Here, in addition to the
25 intermetallic compound 107, tin or the element selected from the group consisting of aluminum, zinc, indium, antimony, bismuth and lead may also be

present in an elemental metal state.

The state "intermetallic compound 107 is dispersed in silicon phase 106" referred to herein is not intended to mean that the powder particle is
5 formed in a state of segregation in which the silicon phase 106 and a phase of the intermetallic compound 107 are separated from each other but is intended to mean the state such that the major component of the powder particle is silicon and the intermetallic
10 compound 107 is present as a mixture therein. Further, such a state can be observed by means of transmission electron microscope or selected-area electron diffraction.

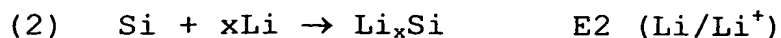
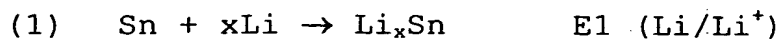
Elements that can form an intermetallic
15 compound with tin are preferably copper, nickel, cobalt, iron, manganese, vanadium, molybdenum, niobium, tantalum, titanium, zircon, yttrium, lanthanum, selenium, magnesium and silver. Of those, copper, nickel and cobalt are more preferable. With
20 tin these form intermetallic compounds such as $\text{Cu}_{41}\text{Sn}_{11}$, $\text{Cu}_{10}\text{Sn}_3$, Cu_5Sn_4 , Cu_5Sn , Cu_3Sn , Ni_3Sn_4 , Ni_3Sn_2 , Ni_3Sn , Co_3Sn_2 , CoSn_2 , CoSn , Fe_5Sn_3 , Fe_3Sn_2 , FeSn_2 , FeSn , Mn_3Sn , Mn_2Sn , MnSn_2 , Sn_3V_2 , SnV_3 , Mo_3Sn , Mo_2Sn_3 , MoSn_2 , NbSn_2 , Nb_6Sn_5 , Nb_3Sn , SnTa_3 , Sn_3Ta_2 , SnTi_2 , SnTi_3 , Sn_3Ti_5 ,
25 Sn_5Ti_6 , SnZr_4 , Sn_2Zr , Sn_3Zr_5 , Sn_2Y , Sn_3Y , Sn_3Y_5 , Sn_4Y_5 , $\text{Sn}_{10}\text{Y}_{11}$, LaSn , LaSn_3 , La_2Sn_3 , La_3Sn , La_3Sn_5 , La_5Sn_3 , La_5Sn_4 , $\text{La}_{11}\text{Sn}_{10}$, Ce_3Sn , Ce_5Sn_3 , Ce_5Sn_4 , $\text{Ce}_{11}\text{Sn}_{10}$, Ce_3Sn_5 ,

Ce₃Sn₇, Ce₂Sn₅, CeSn₃, Mg₂Sn, Ag₃Sn, and Ag₇Sn.

Meanwhile, when silicon is used as an electrode material, because the volume change at the time of the reaction of insertion into silicon and release from silicon of lithium involved in charging/discharging is large, the crystalline structure of silicon will rupture to convert the particles into a fine powder, so that the charging/discharging becomes unable to be performed.

Therefore, the present inventors have previously found that by using amorphized silicon, or a fine powder of a silicon alloy, the cycle life can be improved, and further found that by dispersing in a silicon phase an intermetallic compound comprising tin, or an intermetallic compound comprising an element selected from the group consisting of aluminum, zinc, indium, antimony, bismuth and lead, lithium can be uniformly inserted into the silicon phase, thereby improving the cycle life.

Explaining this by taking a case of tin as one example, the electric potential E1 (Li/Li⁺) of the electrochemical oxidation/reduction reaction (1) of lithium to tin is nobler than the electric potential E2 (Li/Li⁺) of the oxidation/reduction reaction (2) of lithium to silicon.



$E_1 (\text{Li}/\text{Li}^+) > E_2 (\text{Li}/\text{Li}^+)$

Here, since the lithium insertion reaction involved in charging begins from the nobler potential side, it is considered that the lithium insertion
5 begins with tin followed by silicon. Therefore, it is considered that by uniformly dispersing tin in the silicon phase, the lithium insertion reaction into the silicon phase occurs uniformly, so that uniform incorporation of lithium into the silicon phase makes
10 it possible to suppress the breakage of the crystalline structure of silicon.

Meanwhile, industrially convenient means for preparing an alloyed powder of silicon and tin include the so-called gas atomization method that
15 performs alloying by atomizing a mixed and molten material, or the water atomization method. However, because there is a large difference in melting point such that while silicon has a melting point of 1412°C, tin has a melting point of 231.9°C, the alloy powder
20 is liable to be formed in a state such that a silicon phase and a tin phase are separate from each other.

As means to suppress this, as shown in First Invention, it is effective to use an intermetallic compound comprising tin.

25 Specifically, when preparing the alloy, it is effective to adopt a method in which at least one element that forms an intermetallic compound with tin

selected from the group consisting of copper, nickel,
cobalt, iron, manganese, vanadium, molybdenum,
niobium, tantalum, titanium, zirconium, yttrium,
lanthanum, selenium, magnesium and silver is added,
5 along with tin.

Here, because these intermetallic compounds
have a higher melting point than that of tin, the
difference in melting point from silicon can be made
smaller, so that the tin phase and the alloy phase
10 can uniformly be dispersed. Forming the
intermetallic compound is also effective in
suppressing the volume change when incorporating
lithium.

Further, the elements of aluminum, zinc, indium,
15 antimony, bismuth and lead can also electrochemically
insert and release Li, and their oxidation/reduction
reaction potentials for Li are nobler than that of
silicon as is the case with tin. Further, the
melting points of these elements, i.e., aluminum
20 (660°C), zinc (419.5°C), indium (156.4°C), antimony
(630.5°C), bismuth (271°C) and lead (327.4°C), are
lower than that of silicon. Thus, as shown in Second
Invention, by forming an intermetallic compound
containing at least one of these elements to reduce
25 the difference in melting point from silicon, uniform
dispersion can be achieved.

These intermetallic compounds include AlCu,

AlCu₂, AlCu₃, Al₂Cu, Al₂Cu₃, Al₂Cu₇, Al₃Cu₇, Al₄Cu₅, CuZn, CuZn₃, CuZn₄, Cu₅Zn₈, Cu₂In, Cu₄In, Cu₇In₃, Cu₁₁In₉, Cu₂Sb, Cu₃Sb, Cu₄Sb, Cu₅Sb, Cu₁₀Sb₃, BiNi, Bi₃Ni, Bi₃Pb₇ and Pb₃Zr₅.

5 The content of silicon in the alloy is preferably 50% or more by weight in order to exhibit the performance of a high chargeable amount as a lithium secondary battery negative electrode material. Further, the average particle diameter of the silicon
10 alloy primary particles of the present invention is, as a lithium secondary battery negative electrode material, preferably within the range of 0.02 to 5.0 μm , and more preferably within the range of 0.05 to 1.0 μm so that the electrochemical lithium
15 insertion/release reaction occurs rapidly and uniformly. The term "average particle diameter" used herein is intended to mean the average primary particle diameter (average particle diameter in a non-agglomerated state).

20 Here, if the above average particle diameter is too small, handling becomes less easy, the area of contact between particles when forming an electrode increases, thereby increasing the contact resistance. However, in the case of adopting the average particle
25 diameter of the primary particles as mentioned above, making the particles larger by aggregating the primary particles leads to easier handling and

lowering in the resistance.

In order to obtain a battery with a long life cycle, it is preferable that the crystalline structure of a ground fine powder contains an
5 amorphous phase. Further, when a fine powder of a negative electrode material prepared by the method of producing a lithium secondary battery negative electrode material according to the present invention contains an amorphous phase, the volume expansion
10 when alloying with lithium can be reduced.

Further, when the ratio of the amorphous phase becomes larger, the full width at half maximum of a peak of an X-ray diffraction chart, which is sharp for a crystalline material, widens, becoming broader.
15 Incidentally, the full width at half maximum of a main peak of an X-ray diffraction chart of diffraction intensity for 2θ is preferably 0.1° or more, and more preferably 0.2° or more.

The size of the crystallite of the negative
20 electrode material powder (powder of particles comprising silicon as a major component) prepared according to the present invention, in particular in a state in which the electrode structure has not been subjected to charging/discharging yet (i.e., in an
25 unused state) is preferably controlled to be not less than 2 nm but no more than 500 nm, more preferably controlled to be not less than 2 nm but no more than

50 nm, and most preferably controlled to be not less than 2 nm but no more than 30 nm. By using such a fine crystalline powder, the electrochemical reaction during charging/discharging can be performed more smoothly, whereby the charging capacity can be improved. Further, the distortion caused by the insertion/release of lithium during charging/discharging can be minimized to increase the cycle life.

10 In the present invention, the crystallite size of the particles is determined using the following Scherrer equation on the basis of the full width at half maximum of a peak and the diffraction angle of an X-ray diffraction curve using $\text{CuK}\alpha$ as an radiation source.

$$L_c = 0.94\lambda / (\beta \cos\theta) \quad (\text{Scherrer Equation})$$

L_c : crystallite size

λ : wavelength of X-ray beam

β : full width at half maximum of peak (radian)

20 θ : Bragg angle of diffracted rays

Meanwhile, methods for preparing the electrode material according to the present invention includes the following:

(A) A method wherein silicon, tin or aluminum, zinc, indium, antimony, bismuth, lead, a transition metal, or the like are mixed and molten and then subjected to atomization to form an alloy (e.g., gas

atomization or water atomization method);

(B) A method wherein a silicon alloy ingot prepared by mixing and melting silicon, tin or aluminum, zinc, indium, antimony, bismuth, lead, a transition metal
5 or the like is ground;

(C) A method wherein silicon powder, tin powder or a powder of aluminum, zinc, indium, antimony, bismuth, lead, a transition metal, or the like are ground and mixed in an inert gas atmosphere to form an alloy
10 (mechanical alloying); and

(D) A method wherein an alloy is formed from a gas phase by means of plasma, electron beam, laser or induction heating using a volatile chloride (or other halides), oxide or the like.

15 In addition, by mechanically grinding these alloyed powders, it becomes possible to uniformly disperse in a silicon phase an intermetallic compound comprising tin, or at least one intermetallic compound comprising at least one element selected
20 from the group consisting of aluminum, zinc, indium, antimony, bismuth and lead.

Here, as the mechanical grinding apparatus, there are preferably used a ball mill such as a planetary ball mill, a vibrating ball mill, a conical
25 mill and a tube mill; a media mill such as an attrition mill, a sand grinder, an annular mill and a tower mill. The material of the balls as the above

grinding media is preferably zirconia, stainless steel or steel.

Incidentally, the grinding may be performed in either of a wet process or dry process. In wet grinding, the alloy powder is ground in a solvent or ground after a certain amount of solvent is added. The solvent used in wet grinding may be water or an organic solvent such as alcohol, hexane, etc. Examples of alcohol include methyl alcohol, ethyl alcohol, 1-propyl alcohol, 2-propyl alcohol, isopropyl alcohol, 1-butyl alcohol, 2-butyl alcohol and the like.

FIGS. 2A and 2B illustrate schematically sections of an electrode structure according to the present invention. In FIG. 2A, reference numeral 102 denotes an electrode structure. This electrode structure 102 is constituted of an electrode material layer 101 and a current collector 100. This electrode material layer 101 is constituted of, as illustrated in FIG. 2B, particles (active material) 103 comprising silicon as a major component, a conductive auxiliary material 104 and a binder 105. Incidentally, it should be noted that although in FIGS. 2A and 2B the electrode material layer 101 is provided only on one surface of the current collector 100, an electrode material layer may be formed on both sides of the current collector 100 respectively,

depending on the battery configuration.

Here, the content of the conductive auxiliary material 104 is preferably not less than 5% by weight but no more than 40% by weight, and more preferably
5 not less than 10% by weight but no more than 30% by weight. The content of the binder 105 is preferably not less than 2% by weight but no more than 20% by weight, and more preferably not less than 5% by weight but no more than 15% by weight. The content
10 of the particles (powder) 103 comprising silicon as a major component in the electrode material 101 is preferably within the range of 40% by weight to 93% by weight.

The conductive auxiliary material 104 used
15 includes carbonaceous materials such as amorphous carbons such as acetylene black and ketjenblack and graphite structure carbon, nickel, copper, silver, titanium, platinum, aluminium, cobalt, iron, chrome and the like, and especially graphite is preferable.
20 The shape of the conductive auxiliary material may preferably be a shape selected from a spherical shape, a flake shape, a filament shape, a fiber shape, a spike shape, a needle shape, and the like. In addition, by employing two or more different shapes
25 of powders, the packing density when forming the electrode material layer can be increased, thereby reducing the impedance of the electrode structure 102.

The material for the binder 105 may include a water-soluble polymer such as polyvinyl alcohol, water-soluble ethylene-vinyl alcohol copolymer, polyvinyl butyral, polyethylene glycol, sodium
5 carboxymethyl cellulose and hydroxyethyl cellulose; a fluoro-resin such as polyvinylidene fluoride and vinylidene fluoride-hexafluoropropylene copolymer; a polyolefin such as polyethylene and polypropylene; styrene-butadiene rubber, polyamide-imide, polyimide,
10 and polyamic acid (polyamide precursor). Of these, when a combination of polyvinyl alcohol and sodium carboxymethyl cellulose, polyamide-imide or polyamic acid (polyamide precursor) is used, the strength of the electrode increases, whereby an electrode with an
15 excellent charge/discharge cycle characteristic can be manufactured.

In addition, because the current collector 100 has the role of efficiently supplying an electric current to be consumed by the electrode reaction
20 during charging, or collecting an electric current generated during discharging, in particular when applying the electrode structure 102 to a negative electrode of a secondary battery, it is desirable that the current collector 100 is formed of a
25 material that has a high electric conductivity and is inert to the battery reactions. Preferable materials include at least one metallic material selected from

the group consisting of copper, nickel, iron, stainless steel, titanium and platinum. A more preferable material is copper that is inexpensive and has a low electrical resistance.

5 Further, while the shape of the current collector 100 is a plate shape, this "plate shape" is, within the scope of practical use, not particularly limited in thickness, and encompasses the so-called "foil" shape having a thickness of about 100 μm or
10 less. As the plate shape member, for example, a meshy, spongy or fibrous member, punching metal, or expanded metal can also be employed.

Now, a procedure for manufacturing the electrode structure 102 will be explained.

15 First, the conductive auxiliary material 104 and the binder 105 are mixed with a silicon alloy powder of the present invention, to which an appropriate amount of a solvent for the binder 105 is added, followed by kneading to prepare a paste. Then,
20 the prepared paste is applied to the current collector 100 and dried to form the electrode material layer 101, and pressing is then effected to adjust the thickness and density of the electrode material layer 101 thus forming the electrode
25 structure 102.

As the above-mentioned application method, a coater coating method or a screen printing method can

be used. In addition, the above major component along with the conductive auxiliary material 104 and the binder 105, without addition of a solvent, or the above negative electrode material along with the conductive auxiliary material 104 alone, without addition of the binder 105, may be subject to pressure forming on the current collector to form the electrode material layer 101.

Here, if the density of the electrode material layer 101 is too large, the expansion at the time of lithium insertion becomes greater, so that peeling off of the electrode material layer 101 from the current collector 100 occurs, and if the density of the electrode material layer 101 is too small, the resistance of the electrode becomes greater, so that the lowering in charging/discharging efficiency and the drop in voltage of the battery at the time of discharging become greater. For these reasons, the density of the electrode material layer 101 according to the present invention is preferably within the range of 0.8 to 2.0 g/cm³, and more preferably within the range of 0.9 to 1.5 g/cm³.

Incidentally, an electrode structure 102 formed only of the silicon alloy particles of the present invention without using the conductive auxiliary material 104 and the binder 105 can be made by directly forming an electrode material layer 101 on

the current collector 100 using a method such as sputtering, electron beam evaporation, cluster ion beam deposition, or the like.

However, in this case, if the electrode
5 material layer 101 is thick, peeling off is liable to occur at the interface with the current collector 100, so that the above-mentioned direct formation is not suitable for formation of a thick electrode structure 102. Incidentally, in order to prevent the above
10 peeling off, it is preferred that a metal layer or an oxide layer or a nitride layer is provided in a thickness of a nanometer order on the current collector 100 to form an unevenness in the surface of the current collector 100, thereby improving the
15 adhesion at the interface. Examples of the oxide layer and nitride layer preferably include an oxide layer or nitride layer of silicon or a metal.

Meanwhile, the secondary battery according to the present invention comprises a negative electrode
20 using the electrode structure as characterized above, an electrolyte and a positive electrode and utilizes an oxidation reaction of lithium and a reduction reaction of lithium ions.

FIG. 3 is a view schematically showing a basic
25 structure of the lithium secondary battery according to the present invention, in which reference numeral 201 denotes a negative electrode using an electrode

structure of the present invention, reference numeral 202 an ionic conductor, reference numeral 203 a positive electrode, reference numeral 204 a negative electrode terminal, reference numeral 205 a positive
5 electrode terminal and reference numeral 206 a battery case (housing).

Here, the above secondary battery is assembled in such a way that the ionic conductor 202 is sandwiched and stacked between the negative electrode
10 201 and the positive electrode 203 to form an electrode group, then after this electrode group has been inserted into the battery case in dry air or a dry inert gas atmosphere in which the dew point is sufficiently controlled, the electrodes 201, 203 are
15 contacted to the electrode terminals 204, 205, respectively and the battery case is sealed.

Incidentally, when using a member having an electrolyte held in a micro-porous plastic film as the ionic conductor 202, the battery is assembled by
20 inserting a micro-porous plastic film between the negative electrode 201 and the positive electrode 203 as a separator to prevent short-circuiting to form an electrode group, then inserting the electrode group into the battery case, connecting the electrodes 201,
25 203 to the electrode terminals 204, 205, respectively, injecting the electrolyte and sealing the battery case.

The lithium secondary battery that uses an electrode structure comprising an electrode material of the present invention as the negative electrode has a high charging/discharging efficiency and capacity and a high energy density owing to the above-mentioned advantageous effects of the negative electrode.

Herein, the positive electrode 203, which is the counter electrode of the lithium secondary battery using the electrode structure of the present invention as the negative electrode, comprises a positive electrode material that is at least a lithium ion source and serves as a host material for lithium ions, and preferably comprises a layer formed of a positive electrode material that serves as a host material for lithium ions and a current collector. Further, it is preferable that the layer formed of the positive electrode material comprises the positive electrode material that serves as a host material for lithium ions and a binder, and a conductive auxiliary material as occasion demands.

As the positive electrode material that is a lithium ion source and serves as a host material used in the lithium secondary battery of the present invention, there are preferably included lithium-transition metal oxides, lithium-transition metal sulfides, lithium-transition metal nitrides and

lithium-transition metal phosphates. The transition metal for the transition metal oxides, transition metal sulfides, transition metal nitrides or transition metal phosphates includes, for example,

5 metal elements having a d-shell or f-shell, i.e., Sc, Y, lanthanoids, actinoids, Ti, Zr, Hf, V, Nb, Ta, Cr, Mo, W, Mn, Tc, Re, Fe, Ru, Os, Co, Rh, Ir, Ni, Pb, Pt, Cu, Ag, and Au, and in particular Co, Ni, Mn, Fe, Cr, and Ti are preferably used.

10 Where the above positive electrode active material is a powder, the positive electrode is made by using a binder, or made by forming the positive electrode active material layer on the current collector by calcination or deposition. Further,
15 when the conductivity of the powder of the positive electrode active material is low, it becomes necessary to suitably mix a conductive auxiliary material therewith as in the above-mentioned formation of the active material layer for the
20 electrode structure. The conductive auxiliary materials and binders that may be used are the same as those mentioned above for the electrode structure
102 of the present invention.

25 The current collector material used for the positive electrode is preferably a material that has a high electrical conductivity and is inert to the battery reaction, such as aluminium, titanium, nickel

and platinum. Specifically, nickel, stainless steel, titanium and aluminium are preferable, of which aluminium is more preferable because it is inexpensive and has a high electrical conductivity.

5 Further, while the shape of the current collector is a plate shape, this "plate shape" is, within the scope of practical use, not particularly limited in thickness, and encompasses the so-called "foil" shape having a thickness of about 100 μm or less. As the
10 plate shape member, for example, a meshy, spongy or fibrous member, punching metal, or expanded metal can also be employed

In addition, as the ionic conductor 202 of the lithium secondary battery of the present invention,
15 lithium ion conductors such as a separator holding an electrolyte solution (electrolyte solution prepared by dissolving an electrolyte in a solvent), a solid electrolyte, or a solidified electrolyte obtained by gelling an electrolyte solution with a polymer gel, a
20 complex of a polymer gel and a solid electrolyte can be used. Here, the conductivity of the ionic conductor 202 at 25°C is preferably 1×10^{-3} S/cm or more, and more preferably 5×10^{-3} S/cm or more.

As the electrolyte, there may be included salts
25 comprised of lithium ions (Li^+) and Lewis acid ions (BF_4^- , PF_6^- , AsF_6^- , ClO_4^- , CF_3SO_3^- , or BPh_4^- (Ph: phenyl group)) and mixtures thereof. It is preferable that

the above salts have been previously subjected to sufficient dehydration and deoxidation by heating under a reduced pressure or the like.

As a solvent for the electrolyte, there may be included, for example, acetonitrile, benzonitrile, 5 propylene carbonate, ethylene carbonate, dimethyl carbonate, diethyl carbonate, ethylmethyl carbonate, dimethyl formamide, tetrahydrofuran, nitrobenzene, dichloroethane, diethoxyethane, 1,2-dimethoxyethane, 10 chlorobenzene, γ -butyrolactone, dioxolane, sulfolane, nitromethane, dimethyl sulfide, dimethyl sulfoxide, methyl formate, 3-methyl-2-oxazolidinone, 2-methyltetrahydrofulan, 3-propylsydnone, sulfur dioxide, phosphoryl chloride, thionyl chloride, 15 sulfuryl chloride or a liquid mixture thereof.

Incidentally, it is preferable to either dehydrate the above-mentioned solvent, for example, with activated alumina, a molecular sieve, phosphorus pentaoxide or calcium chloride, or depending on the 20 solvent, to distill the solvent in an inert gas atmosphere in the presence of an alkaline metal for elimination of impurities and dehydration.

In order to prevent leakage of the electrolyte solution, it is preferable to use a solid electrolyte 25 or a solidified electrolyte. The solid electrolyte may include a glass material such as an oxide material comprising lithium, silicon, oxygen, and

phosphorus or sulfur elements, a polymer complex of an organic polymer having an ether structure. The solidified electrolyte is preferably obtained by gelling the above electrolyte solution with a gelling agent to solidify the electrolyte solution.

It is desirable to use as the gelling agent a polymer that can absorb the solvent of the electrolyte solution to swell, or a porous material capable of absorbing a large amount of liquid, such as silica gel. As the polymer, there may be used polyethylene oxide, polyvinyl alcohol, polyacrylonitrile, polymethylmethacrylate, vinylidene fluoride-hexafluoropropylene copolymer, and the like. Further, it is more preferred that the polymers have a cross-linking structure.

The ionic conductor 202 constituting the separator which plays the role of preventing short-circuiting between the negative electrode 201 and the positive electrode 203 in the secondary battery may also have a role of retaining the electrolyte solution and is required to have a large number of fine pores through which lithium ions can pass and to be insoluble and stable in the electrolyte solution.

Accordingly, as the material of the ionic conductor 202 (separator), there are preferably used, for example, a material of a micropore structure made of glass, a polyolefin such as polypropylene or

polyethylene, a fluororesin, etc., or a nonwoven fabric. Alternatively, a metal oxide film having micropores or a resin film complexed with a metal oxide may also be used.

5 Now, the shape and structure of the secondary battery will be explained.

 The specific shape of the secondary battery according to the present invention may be, for example, a flat shape, a cylindrical shape, a
10 rectangular parallelepiped shape, a sheet shape or the like. The structure of the battery may be, for example, a single layer type, a multiple layer type, a spiral-wound type or the like. Of those, a spiral-wound type cylindrical battery permits an enlarged
15 electrode surface area by rolling a separator that is sandwiched between a negative electrode and a positive electrode, thereby being capable of supplying a large current at the time of charging/discharging. Furthermore, batteries having
20 a rectangular parallelepiped shape or sheet shape permit effective utilization of accommodation space in appliances that will be configured by accommodating a plurality of batteries therein.

 Now, description will be made in more detail of
25 the shape and structure of the battery with reference to FIGS. 4 and 5. FIG. 4 is a sectional view of a single layer type flat (i.e., coin type) battery and

FIG. 5 is a sectional view of a spiral-wound type cylindrical battery. These lithium secondary batteries generally comprise the same structure as that illustrated in FIG. 3, a negative electrode, a positive electrode, an electrolyte, an ionic conductor, a battery housing and an output terminal.

In FIGS. 4 and 5, reference numerals 301, 403 denote negative electrodes, reference numerals 303, 406 positive electrodes, reference numerals 304, 408 negative electrode caps or negative electrode cans as negative electrode terminals, reference numerals 305, 409 positive electrode caps or positive electrode cans as positive electrode terminals, reference numeral 302, 407 ionic conductors, reference numerals 306, 410 gaskets, reference numeral 401 represents a negative electrode current collector, reference numeral 404 a positive electrode current collector, reference numeral 411 an insulating plate, reference numeral 412 a negative electrode lead, reference numeral 413 a positive electrode lead, and reference numeral 414 a safety valve.

In the flat secondary battery (coin type) shown in FIG. 4, the positive electrode 303 that contains a positive electrode material layer and the negative electrode 301 that contains a negative electrode material layer are stacked with an ionic conductor 302 which is formed by a separator that retains at

least an electrolyte solution therein, wherein the stack is accommodated from the positive electrode side into the positive electrode can 305 used as a positive terminal and the negative electrode is
5 covered with the negative electrode cap 304 used as a negative electrode. A gasket 306 is provided in the remaining portions of the positive electrode can.

In the spiral-wound type cylindrical secondary battery shown in FIG. 5, the positive electrode 406
10 having a positive electrode (material) layer 405 formed on the positive electrode current collector 404 and the negative electrode 403 having the negative electrode (material) layer 402 formed on the negative electrode current collector 401 are provided
15 in opposition to each other via the ionic conductor 407 formed by a separator that retains at least an electrolyte solution therein so as to form a stack of a cylindrical structure rolled up multiple times.

The cylindrical stack is accommodated in the
20 negative electrode can 408 used as the negative electrode terminal. Furthermore, the positive electrode cap 409 is disposed as the positive electrode terminal on a side of an opening of the negative electrode can 408 and a gasket 410 is
25 disposed in the remaining parts of the negative electrode can. The cylindrical electrode stack is isolated from the positive electrode cap side by the

insulating plate 411.

The positive electrode 406 is connected to the positive electrode cap 409 by way of the positive electrode lead 413. The negative electrode 403 is
5 connected to the negative electrode cap 408 by way of the negative electrode lead 412. The safety valve 414 is disposed on the side of the positive electrode cap to adjust the internal pressure of the battery. As mentioned above, a layer comprising the above
10 negative electrode material fine powder of the present invention is used as the active material layer 402 of the negative electrode 403.

Next, an example of assembling procedures for the battery shown in FIGS. 4 and 5 will be described.

15 (1) The ionic conductor 302, 407 as a separator is sandwiched between the negative electrode 301, 403 and the formed positive electrode 303, 406, and assembled into the positive electrode can 305 or the negative electrode can 408.

20 (2) After injection of the electrolyte solution, the negative electrode cap 304 or the positive electrode cap 409 is assembled with the gasket 306, 410.

(3) The assembly obtained in (2) above is caulked.

25 The battery is completed in this way.

Incidentally, it is preferable that the above-described preparation of the materials for the

lithium battery and assembly of the battery is carried out in dry air from which moisture has been removed sufficiently or in a dry inert gas.

Next, members comprising the secondary battery
5 will be described.

As the material of the gasket 306, 410, there may be used, for example, a fluororesin, a polyolefin resin, a polyamide resin, a polysulfone resin, or a rubber material. The sealing of the battery may be
10 conducted by way of glass-sealing, sealing using an adhesive, welding or soldering, besides the caulking using the insulating packing shown in FIGS. 4 or 5. As the material of the insulating plate 411 shown in FIG. 4, organic resin materials and ceramics may be
15 used.

The battery housing is constituted of the positive electrode can 305 or the negative electrode can 408, and the negative electrode cap 304 or the positive electrode cap 409. As the material of the
20 battery housing, stainless steel is preferably used. Further, as other materials of the battery housing, there are frequently used an aluminum alloy, a titanium clad stainless steel, a copper clad stainless steel or a nickel-plated steel.

25 The positive electrode can 305 illustrated in FIG. 4 and the negative electrode can 408 illustrated in FIG. 5 function as the battery housing (case) and

also as a terminal and is therefore preferably made of stainless steel. However, where the positive electrode 305 or the negative electrode 408 does not function as both the battery housing (case) and the
5 terminal, in addition to stainless steel, a metal such as zinc, a plastic such as polypropylene, a composite material of a metal or glass fibers and a plastic may be used.

As the safety valve 414 provided in the lithium
10 secondary battery in order to ensure safety when the internal pressure in the battery is increased, for example, rubber, a spring, a metal ball or a rupture disk may be used.

(Examples)

15 In the following, the present invention will be described in more detail with reference to examples.

(Preparation of Electrode Material)

First, examples for the preparation of a negative electrode material will be explained.

20 (Example 1)

65% by weight of Si, 30% by weight of Sn and 5% by weight of Cu were melted and mixed to make an alloy, which was subjected to water atomization to prepared a Si-Sn-Cu alloy powder having an average
25 particle diameter of 10 μm . Next, the prepared alloy powder was ground with a bead mill (ball mill using beads with comparatively small diameter as grinding

media) to obtain a Si-Sn-Cu alloy fine powder. This grinding was performed using zirconia beads in isopropyl alcohol.

Then, processing for 2 hours in a high-energy
5 planetary-type ball mill in an argon gas atmosphere using balls made of silicon nitride provided an electrode material of Si-Sn-Cu alloy fine powder.
(Example 2)

An electrode material of a Si-Zn-Cu alloy fine
10 powder was obtained following the same procedure as Example 1 with the exception that an alloy with a composition of 70% by weight of Si, 25% by weight of Zn and 5% by weight of Cu was prepared by a gas atomization process using nitrogen gas.
15 (Example 3)

An electrode material of a Si-Sn-Co alloy fine powder was obtained following the same procedure as Example 1 with the exception that an alloy with a composition of 50% by weight of Si, 40% by weight of
20 Sn and 10% by weight of Co was prepared by a water atomization process.
(Example 4)

An electrode material of a Si-Sn-Ni alloy fine powder was obtained following the same procedure as
25 Example 1 with the exception that an alloy with a composition of 85% by weight of Si, 10% by weight of Sn and 5% by weight of Ni was prepared by a water

atomization process.

(Reference Example 1)

An electrode material of a Si-Sn-Cu alloy fine powder was obtained following the same procedure as
5 Example 1 with the exception that the processing in a high-energy planetary-type ball mill was not performed.

(Reference Example 2)

An electrode material of a Si-Zn-Cu alloy fine
10 powder was obtained following the same procedure as Example 2 with the exception that the processing in a high-energy planetary-type ball mill was not performed.

(Reference Example 3)

15 An electrode material of a Si-Sn-Co alloy fine powder was obtained following the same procedure as Example 3 with the exception that the processing in a high-energy planetary-type ball mill was not performed.

20 (Reference Example 4)

An electrode material of a Si-Sn-Ni alloy fine powder was obtained following the same procedure as
Example 4 with the exception that the processing in a high-energy planetary-type ball mill was not
25 performed.

Next, the results of analyzing the electrode materials obtained in Examples 1 to 4 and Reference

Examples 1 to 4 will be explained.

The above Si alloy electrode materials were analyzed from the viewpoint of factors that are considered to affect the performance of a negative
5 electrode of a lithium secondary battery, such as average particle diameter, crystallite size, intermetallic compounds of Sn or Zn, and distribution of elements in the alloy.

Here, the average particle diameter was
10 determined by a laser diffraction/scattering particle size distribution analyzer, and further observed with a scanning electron microscope (SEM). Further, the crystallite size was calculated from the full width at half maximum of an X-ray diffraction peak in
15 accordance with the Scherrer equation, and detection of Sn or Zn intermetallic compounds was performed by investigation using the selected-area electron diffraction.

Further, the distribution of elements in the
20 alloy was investigated by TEM observation in terms of nonuniformity in color density within the alloy particle. Incidentally, when the localization of elements in the alloy is small and the elements are uniformly dispersed, an image with less nonuniformity
25 in color density within the alloy particle is observed, and in elemental mapping by the energy dispersive X-ray spectroscopy (EDXS) combined with

TEM, less localization of elemental distribution within the particle is observed.

The electrode material made in Example 1 was measured for particle size distribution with a laser diffraction /scattering particle size distribution analyzer (model: LA-920 manufactured by Horiba Ltd.), with the result that the median diameter was 0.28 μm . FIG. 6 is a photograph of the electrode material obtained by SEM observation, from which it was seen that the electrode material (negative electrode material) were uniform particles of 0.5 μm or less.

In addition, X-ray diffraction measurement was carried out to obtain the profile of FIG. 7. The crystallite size calculated from the Scherrer equation using the full width at half maximum of a peak at $28^\circ \pm 1$ as a main peak of silicon was 11.1 nm.

Further, electron diffraction was performed at a selected-area region of a diameter of 150 nm adopted in the TEM observation. The results are collectively shown in FIG. 8. Incidentally, as to the ring diffraction pattern of FIG. 8, the calculated d values are collectively shown in Table 1.

(Table 1)

d value calculated from electron diffraction results of material made in Example 1	d value of Si (JCPDS card number: 27- 1402)	d value of Cu ₆ Sn ₅ (JCPDS card number: 02-0713)
3.13	3.14	
2.93		2.96
2.55		2.55
2.09		2.09
		2.08
1.90	1.92	
		1.71
1.63		1.62

Thus, it was seen from Table 1 that the d values calculated from the results of electron diffraction of the electrode material made in Example 1 were quite similar to the d values of the JCPDS card number for Cu₆Sn₅, which meant the presence of Cu₆Sn₅.

Further, Examples 2 to 4 were also investigated in the same manner as described above, and the average particle diameter, crystallite size, and observed intermetallic compounds of the electrode materials made in Example 1 to 4 are collectively shown in Table 2.

(Table 2)

		Average particle diameter (μm)	Crystal- lite size (nm)	Observed intermetallic compound
Example 1	Si/Sn/Cu = 65/30/5 (weight ratio)	0.28	11.1	Cu_6Sn_5
Example 2	Si/Zn/Cu = 85/10/5 (weight ratio)	0.24	11.3	Cu_5Zn_8
Example 3	Si/Sn/Co = 50/40/10 (weight ratio)	0.49	11.7	CoSn , Co_3Sn_2 , Co_3Sn
Example 4	Si/Sn/Ni = 85/10/5 (weight ratio)	0.25	10.5	Ni_3Sn_2

Thus, it was seen from Table 2 that for the Si alloys made in Examples 1 to 4, the average particle diameter was 0.24 to 0.49 μm , the crystallite size was 10.5 to 11.7 nm, and further that Sn intermetallic compounds or Zn intermetallic compounds were present.

Next, the elemental distributions in the alloys using the electrode materials made in Example 1 and Reference Example 1 were investigated. FIGS. 9 and 10 are photographs obtained by TEM observation of the electrode materials made in Example 1 and Reference Example 1. Further, FIGS. 11 and 12 show the results of elemental mapping using the EDXS analysis.

From these results, it was seen that the portion of a low color density was an Si phase, and the portions of high color densities were an Sn phase and a Cu_6Sn_5 phase. It was seen from FIG. 9 that the electrode material made in Example 1 was small in nonuniformity of color density, and therefore that the Sn phase and the Sn_6Cu_5 phase were dispersed uniformly in the Si phase. In contrast, it was seen from FIG. 10 that the electrode material made in Reference Example 1 was large in nonuniformity of color density within the alloy particle, and therefore that the Si phase and the Sn phase and the Sn_6Cu_5 phase were present nonuniformly within the particles.

Further, the same observation results were obtained for Example 2 and Reference Example 2, Example 3 and Reference Example 3, and Example 4 and Reference Example 4.

Next, as will be described below, electrode structures were manufactured using the fine powders of the silicon alloys obtained following the procedures described above and evaluated for the lithium insertion/release performance thereof.

First, 66.5% by weight of each of the silicon alloy fine powders obtained by the above procedure, 10.0% by weight of a flat graphite powder as a conductive auxiliary material (specifically, graphite

powder with a substantially disk-shaped particles of a diameter of about 5 μm and a thickness of about 5 μm), 6.0% by weight of a graphite powder (substantially spherical particles with an average particle size of 0.5 to 1.0 μm), 4.0% by weight of an acetylene black powder (substantially spherical particles with an average particle size of 4×10^{-2} μm), 10.5% by weight of polyvinyl alcohol as a binder and 3.0% by weight of sodium carboxymethyl cellulose were mixed and kneaded with addition of water to prepare a paste.

Next, the thus prepared paste was applied on an electrical field copper foil (electrochemically produced copper foil) of 15 μm in thickness by means of a coater and dried, and the thickness was adjusted with a roller press machine to obtain an electrode structure having an active material layer with a thickness of 25 μm .

The resultant electrode structure was cut into a shape/size of 2.5 cm \times 2.5 cm square and a copper tub was welded thereto to obtain a silicon electrode. (Evaluation Procedure for Lithium Insertion/Release)

Next, a lithium metal foil of 100 μm in thickness was pressure bonded to a copper foil to make a lithium electrode. Next, ethylene carbonate and diethyl carbonate were mixed at a volume ratio of 3:7 to obtain an organic solvent, to which a LiPF_6

salt was dissolved at a concentration of 1 M (mol/L) to prepare an electrolyte solution.

Then, the electrolyte solution was impregnated into a porous polyethylene film of 25 μm in thickness. 5 Next, the above silicon electrode was arranged on one surface of the polyethylene film and the above lithium electrode was arranged on the other surface of the polyethylene film such that the polyethylene film was sandwiched by the electrodes. In order to 10 provide flatness, this stack was pinched by a pair of glass sheets, and then covered with an aluminum laminated film to make an evaluation cell.

This aluminum laminated film was a three-layered film consisting of an outermost nylon film 15 layer, a middle aluminum foil layer with a thickness of 20 μm , and an inside polyethylene film layer. The output terminal portions of the electrodes were sealed by fusion without lamination.

In order to evaluate the performance of the 20 above electrode structure as a negative electrode, a lithium insertion/release cycle test (charge/discharge cycle test) was performed.

Namely, the evaluation cell was connected to a charging/discharging apparatus with the lithium 25 electrode being the anode and the silicon electrode being the cathode. First, the evaluation cell was discharged at a current density of 0.112 mA/cm^2 (70

mA per 1 g of the active material layer of the silicon electrode, that is, 70 mA/gram of electrode layer weight) to insert lithium into the silicon electrode layer, then the evaluation cell was charged
5 at a current density of 0.32 mA/cm² (200 mA/gram of electrode layer weight) to release lithium from the silicon layer, and the electricity amount involved in lithium insertion/release per unit weight of the silicon electrode layer, or the silicon powder or
10 silicon alloy powder was evaluated at a voltage range of 0 to 1.2 V.

FIG. 13 is a view showing the results of the lithium insertion/release cycle test of the electrode structures of Examples 1 to 4 and Reference Examples
15 1 to 4, wherein the abscissa indicates the number of cycles and the ordinate represents the amount of lithium released.

As shown by FIG. 13, for the electrodes of Reference Examples 1 to 4 in which the intermetallic
20 compound of Sn or Zn is not uniformly disperse in the Si phase, the amount of Li released decreases as the cycles are repeated. However, for the electrodes of Examples 1 to 4 of the present invention where the intermetallic compound of Sn or Zn is uniformly
25 disperse in the Si phase, the amount of Li released does not decrease. Thus, it was seen that the silicon alloy electrodes made in the examples of the

present invention each had a longer life.

Next, a secondary battery was made as Example 5 of the present invention.

(Example 5)

5 In this example, an electrode structure having electrode layers formed on both sides of a current collector was made using a negative electrode material according to the present invention. The thus made electrode structure was used as a negative
10 electrode to make a lithium secondary battery of a 18650 size (diameter 18 mm ϕ \times height 65 mm) having the sectional structure as shown in FIG. 5.

1. Preparation of Negative Electrode 403

15 The negative electrode 403 was made according to the following procedure using the electrode materials of Examples 1 to 4.

20 First, 66.5% by weight of each of the silicon alloy fine powders obtained by the above procedure, 10.0% by weight of a flat graphite powder as a conductive auxiliary material (specifically, graphite powder with a substantially disk-shaped particles of a diameter of about 5 μ m and a thickness of about 5 μ m), 6.0% by weight of a graphite powder (substantially spherical particles with an average
25 particle size of 0.5 to 1.0 μ m), 4.0% by weight of an acetylene black powder (substantially spherical particles with an average particle size of 4×10^{-2}

μm), and 13.5% by weight of a binder were mixed, and N-methyl-2-pyrrolidone was added to prepare a paste.

Incidentally, as the binder, polyamide-imide was used for the electrode materials of Examples 1 and 2, and polyamic acid (polyamide precursor) was used for the electrode materials of Examples 3 and 4.

Next, the thus prepared paste was applied on an electrical field copper foil (electrochemically produced copper foil) of 15 μm in thickness by means of a coater and dried, and the thickness was adjusted with a roller press machine to prepare an electrode structure having an active material layer with a thickness of 25 μm.

The electrode structure having electrode layers provided on both sides of the current collector according to the above procedure was cut into a predetermined size, and a lead of a nickel ribbon was connected to the electrode by spot welding to obtain the negative electrode 403.

2. Preparation of Positive Electrode 406

(1) Lithium citrate and cobalt nitrate were mixed at a molar ratio of 1:3, followed by addition of citric acid, and the resulting mixture was then dissolved in ion-exchanged water to obtain a solution. The solution was sprayed into an air stream of 200°C to prepare a precursor of a lithium-cobalt oxide fine powder.

(2) The precursor of a lithium-cobalt oxide prepared in above (1) was heat-treated in an air stream at 850°C.

(3) The lithium-cobalt oxide prepared in above (2) was mixed with 3% by weight of a graphite powder and 5% by weight of a polyvinylidene fluoride powder, to which N-methyl-2-pyrrolidone was then added to make a paste.

(4) The paste obtained in above (3) was applied on both surfaces of an aluminium foil of a thickness of 20 μm as the current collector 404, then dried and the thickness the positive electrode material layer on each side was adjusted with a roller press machine to 90 μm . Further, an aluminium lead was connected by an ultrasonic welding machine, and dried at 150°C under a reduced pressure to prepare the positive electrode 406.

3. Preparation Procedure of Electrolyte Solution

(1) Ethylene carbonate and diethyl carbonate whose moisture had been sufficiently removed were mixed at a volume ratio of 3:7 to prepare a solvent.

(2) Into the solvent obtained in above (1) was dissolved lithium tetrafluoroborate (LiBF_4) at a concentration of 1 M (mole/L) to obtain an electrolyte solution.

4. Separator 407

A microporous polyethylene film of 25 μm in

thickness was used as the separator.

5. Battery Assembly

Assembly was entirely conducted in a dry atmosphere controlled in moisture with a dew point of
5 -50°C or less.

The separator 407 was sandwiched between the negative electrode 403 and the positive electrode 406, and the sandwiched member was then spirally wound so as to have a structure of separator/positive
10 electrode/separator/negative electrode/separator, and inserted in the negative electrode can 408 made of stainless steel.

Next, the negative electrode lead 412 was spot-welded to a bottom portion of the negative electrode
15 can 408. A constriction was formed at an upper portion of the negative electrode can by means of a necking machine, and the positive electrode lead 413 was welded to the positive electrode cap 409 provided with a gasket 410 made of polypropylene by means of a
20 spot welding machine.

(3) Next, after an electrolyte solution had been injected, the positive electrode cap was put on, and the positive electrode cap and the negative electrode can were caulked with a caulking machine and sealed
25 to prepare the battery.

Incidentally, the battery was a positive electrode capacity regulated battery in which the

negative electrode capacity was larger than the positive electrode capacity.

(6) Evaluation

Charging/discharging was performed for each of
5 the batteries, and the discharging capacity was measured.

As a result, the discharging capacities of the lithium secondary batteries using the electrode structures formed of the electrode materials of
10 Examples 1 to 4 as the negative electrodes all exceeded 2800 mAh. Further, even at the 100th cycle, discharging capacities corresponding to 75% or more of the initial capacities were maintained.

As described above, according to the preferable
15 examples of the present invention, a high capacity secondary battery can be produced in which a drop in capacity due to repeated charging/discharging is small, and the charge/discharge cycle life is improved.